

Work Order ID 117326

June-16-14 10:55:11 AM

117326

Page 1

Item ID: D4870-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: End Fitting, Small
 Start Date: 6/16/14 Start Qty: 5.00 ***5*** Cust Item ID:
 Required Date: 6/16/14 Req'd Qty: 5.00 ***5*** Customer:
 Reference: PART MARKING

Approvals: Process Plan: MLJ Date: 140614 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4870	REV A

105

0.00

105

Purchasing

Purchasing

Memo

PULL FROM STK:
 5 X D4870-1 B112016
 SEND TO P & L PRINTING FOR PART MARKING
 PO 24622

0.00

u 14-06-16

N/A already approved on Haas

CY 14/10/17

108

Receive & Inspect for Damage & Mat'l Certs

0.00

108

Packaging

Packaging

Memo

0.00

PO 14/6/18 (5)

110

QC6- Inspect dimensions to drawing

0.00

110

QC

Quality Control

Memo

0.00

POSITIVE RECALL

EFFECTIVE 14-06-19 AUTH h p/s.

RELEASED h DATE 14-06-19

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
125	Identify as per dwg & Stock Location: _____	0.00							
125									
Packaging	Memo	0.00							
Packaging	RE-IDENTIFY USING NEW B/N								
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

u 14,0620
 O

Picklist Print

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June-16-14 10:55:11 AM

Work Order ID: 117326

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Parent Item: D4870-1

D4870-1

Parent Item Name: End Fitting, Small

Start Date: 6/16/14

Required Date: 6/16/14

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP REV:A NEW ISSUE 14-01-28 JLM VERIFIED BY:JFS

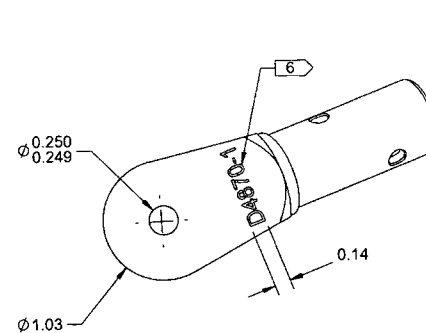
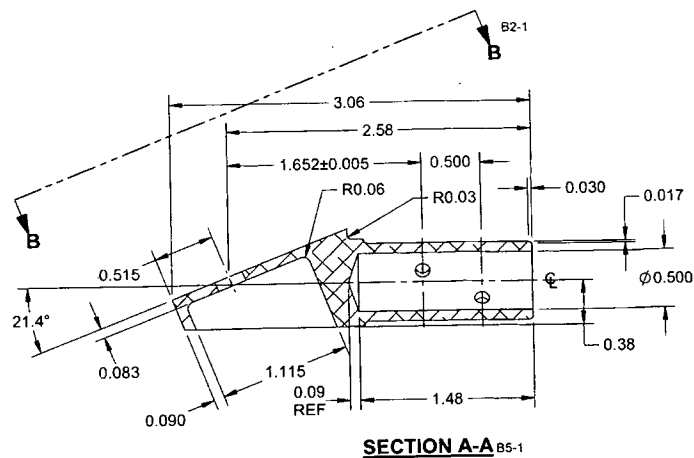
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4870-1		Manufactured	No				Each	0.0000		5			
D4870-1									**				
End Fitting, Small													

112016

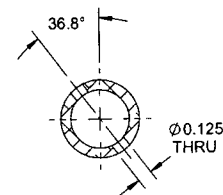
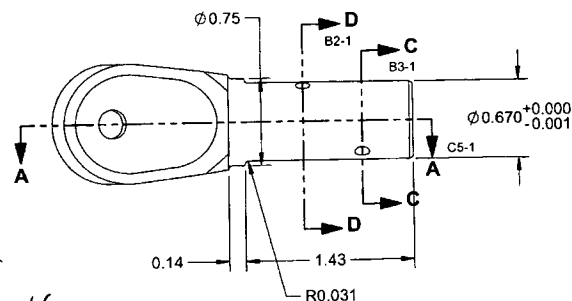
SHIP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 117326 MJS
14-06-16

NOTES:

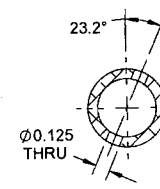
- 1) MATERIAL: 17-4 PH/S17400/TYPE 630 SS ROUND BAR, H900 CONDITION
PER AMS 5643/ASTM A564
DART SPEC M17-4-R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.3.
ENGRAVE P/N USING 0.14 HIGH LETTERS TO A MAX. DEPTH OF 0.010
- 7) WEIGHT: 0.18 lbs
- 8) LIQUID PENETRANT INSPECT PER QSI 038 6.1.1 (ASTM E1417 LEVEL 2)



AUXILIARY VIEW B-B D5-1



SECTION C-C B5-1



SECTION D-D B6-1

D4870-1 END FITTING, SMALL

APPROVED

A	NEW ISSUE		RF	13.09.16
REV.		DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD		
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA		
CHECKED	HS	DRAWING NO.	REV. A	
MFG. APPR.	JLM	D4870		SHEET 1 OF 2
APPROVED	HS	TITLE		SCALE
DE APPR.	DS	END FITTING		NTS
DATE	13.12.09	COPYRIGHT © 2013 BY DART AEROSPACE LTD		
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